

P502-563

DART AEROSPACE LTD	Work Order: 22211
Description: Heli-Utility-Basket, Lightweight	Part Number: D350-721-041
Drawing:	Qty: 1
Ref: IIN-D350-721 Rev. A page 7,8; D3325 Rev. A page 1	Page 1 of 2

Step	Location	Procedure	By	Date	Qty																																																																																																								
1	DC	Issue Travelers for: D350-721-041 Utility Basket Assy, LH/RH <u>Batch</u> D3324-041 Basket Base Assembly <u>22211</u> D3325-041 Basket Lid Assembly <u>22211</u> Drawing not required	JJ	05.02.18	1																																																																																																								
2	DC	Photocopy bluefile and create labels per PPP D350-721-041 CHG001	N/A	JJ																																																																																																									
3	WS	Go to Travelers D3324-041 & D3325-041	DD	05/02/18	1																																																																																																								
4	GA	Pick: Assembly Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2022-101</td><td>Spacer</td><td>M21505</td></tr><tr><td>1</td><td>D2332-041</td><td>Prop Assembly</td><td>B21221</td></tr><tr><td>1</td><td>D2530</td><td>Handle Assembly</td><td>B21970</td></tr><tr><td>2</td><td>D2535</td><td>Spring</td><td>B20827</td></tr><tr><td>2</td><td>D2537</td><td>Bushing</td><td>B21548</td></tr><tr><td>1</td><td>D2729-1</td><td>Label</td><td>N/A</td></tr><tr><td>2</td><td>D2931</td><td>Bumper</td><td>B21139</td></tr><tr><td>1</td><td>D3320-041</td><td>Webbing</td><td>N/A</td></tr><tr><td>1</td><td>D3351-1</td><td>Label</td><td>N/A</td></tr><tr><td>2</td><td>AN3-16A</td><td>Bolt</td><td>M14820</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>M15321</td></tr><tr><td>1</td><td>AN4-20A</td><td>Bolt</td><td>M12082</td></tr><tr><td>1</td><td>AN4-22A</td><td>Bolt</td><td>M3735</td></tr><tr><td>4</td><td>AN5-17A</td><td>Bolt</td><td>M15702</td></tr><tr><td>4</td><td>AN960JD416</td><td>Washer</td><td>M5519</td></tr><tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>M3154</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M15927</td></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M9636</td></tr><tr><td>32</td><td>AN960JD9</td><td>Washer</td><td>N/A</td></tr><tr><td>4</td><td>AN970-4</td><td>Washer</td><td>M16504</td></tr><tr><td>32</td><td>MS20600AD4W2</td><td>Rivet</td><td>N/A</td></tr><tr><td>2</td><td>MS20600AD4W3</td><td>Rivet</td><td>M14660</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M15066</td></tr><tr><td>4</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15020</td></tr><tr><td>4</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M15539</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D2022-101	Spacer	M21505	1	D2332-041	Prop Assembly	B21221	1	D2530	Handle Assembly	B21970	2	D2535	Spring	B20827	2	D2537	Bushing	B21548	1	D2729-1	Label	N/A	2	D2931	Bumper	B21139	1	D3320-041	Webbing	N/A	1	D3351-1	Label	N/A	2	AN3-16A	Bolt	M14820	2	AN4-7A	Bolt	M15321	1	AN4-20A	Bolt	M12082	1	AN4-22A	Bolt	M3735	4	AN5-17A	Bolt	M15702	4	AN960JD416	Washer	M5519	2	AN960JD416L	Washer	M3154	4	AN960JD516	Washer	M15927	2	AN960JD8	Washer	M9636	32	AN960JD9	Washer	N/A	4	AN970-4	Washer	M16504	32	MS20600AD4W2	Rivet	N/A	2	MS20600AD4W3	Rivet	M14660	2	MS21042L3	Nut (or -3)	M15066	4	MS21042L4	Nut (or -4)	M15020	4	MS21042L5	Nut (or -5)	M15539	DD	05/02/18	1
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5	PK	Pick: Packing Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>3</td><td>D2230-1</td><td>Lug</td><td></td></tr><tr><td>4</td><td>D2230-3</td><td>Clamp</td><td></td></tr><tr><td>4</td><td>D2856-400-720</td><td>Abrasion Strip</td><td></td></tr><tr><td>2</td><td>AN4-12A</td><td>Bolt</td><td></td></tr><tr><td>8</td><td>AN4-13A</td><td>Bolt</td><td></td></tr><tr><td>4</td><td>AN4-14A</td><td>Bolt</td><td></td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td></td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	3	D2230-1	Lug		4	D2230-3	Clamp		4	D2856-400-720	Abrasion Strip		2	AN4-12A	Bolt		8	AN4-13A	Bolt		4	AN4-14A	Bolt		24	AN960JD416	Washer		16	MS21042L4	Nut (or -4)			N/A																																																																					
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05-03-02

D3328-1
D3350-041

Lug
STRUT.

M21202

RELEASED
1/14/2014

P502-563

DART AEROSPACE LTD	Work Order: 22 22211
Description: Heli-Utility-Basket, Lightweight	Part Number: D350-721-041
Drawing:	Qty:
Ref: IIN-D350-721 Rev. A page 7,8; D3325 Rev. A page 1	Page 2 of 2

Step	Location	Procedure	By	Date	Qty												
6	GA	Assemble as per Dwg IIN-D350-721 Attach Travelers: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3324-041</td><td>Basket Base Assy</td><td>22211</td></tr><tr><td>1</td><td>D3325-041</td><td>Basket Lid Assy</td><td>22211</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3324-041	Basket Base Assy	22211	1	D3325-041	Basket Lid Assy	22211	MD	05/03/02	1
Qty	Part Number	Description	Batch														
1	D3324-041	Basket Base Assy	22211														
1	D3325-041	Basket Lid Assy	22211														
7	QC5	Inspect for foreign objects as per QSI 024 & Assembly work to Step 6	JN/A														
8	QC4	Inspect Kit;100% for completeness on the W/O															
9	PK	Identify and pack for shipping as per PPP D350-721-041															
10	AC	Cost / part: <u>CHARGE TO P502-563</u>	Sue	05-03-17	1												
11	DC	Close Work Order and Ensure Travelers Attached Inspect Level 21 Travelers: D350-721-041 D3324-041 D3325-041	05.03.22	05.03.22	1												

Rev	Date	Change	Revised By	Approved
A	04.11.10	New issue	KJ/JLM	
B	05.02.09	Now made in-house	KJ/JLM	

RELEASED
05-03-02

P502-563

DART AEROSPACE LTD		Work Order: 22211
Description: <u>Basket</u>		Part Number: A350-721-041
Dwg:		Qty:
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveller																																																			
①		Cut 5" x 2" x .035" wall 4130 tubing for Lid and Base <u>Batch: M16550</u>	AP	05/01/18	1																																																
②		Clean oil on and inside of tubing	AP	05/01/18	1																																																
③		Drill hole	AP	05/01/18	1																																																
④		Deburr	AP	05/01/18	1																																																
⑤		Pick all parts	AP	05/01/18	1																																																
⑥		Weld	AP	05/01/18	1																																																
<table border="1"> <thead> <tr> <th>Qty</th><th>P#</th><th>Description</th><th>Batch</th><th></th><th></th></tr> </thead> <tbody> <tr> <td>1</td><td>2</td><td>A3328-1 Hinge</td><td>M16559</td><td>AD</td><td rowspan="7">} 05/01/18 1</td></tr> <tr> <td>1</td><td>2</td><td>A3328-3 Hinge</td><td>M16559</td><td>AD</td></tr> <tr> <td>1</td><td>2</td><td>A3349-1 Bushing</td><td>M16440</td><td>AD</td></tr> <tr> <td>1</td><td>2</td><td>A3349-3 Bushing</td><td>M16440</td><td>AD</td></tr> <tr> <td>1</td><td>4</td><td>A3348-1 Mounting Bracket</td><td>M16559</td><td>AD</td></tr> <tr> <td>1</td><td>4</td><td>A3348-3 Mounting Bracket</td><td>M16559</td><td>AD</td></tr> <tr> <td>1</td><td>1</td><td>A3352-1 Label Plate</td><td>M9131</td><td>AD</td></tr> <tr> <td></td><td></td><td>Expanded Metal</td><td>M16440</td><td>AD</td><td></td></tr> </tbody> </table>						Qty	P#	Description	Batch			1	2	A3328-1 Hinge	M16559	AD	} 05/01/18 1	1	2	A3328-3 Hinge	M16559	AD	1	2	A3349-1 Bushing	M16440	AD	1	2	A3349-3 Bushing	M16440	AD	1	4	A3348-1 Mounting Bracket	M16559	AD	1	4	A3348-3 Mounting Bracket	M16559	AD	1	1	A3352-1 Label Plate	M9131	AD			Expanded Metal	M16440	AD	
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1	1	A3352-1 Label Plate	M9131	AD																																																	
		Expanded Metal	M16440	AD																																																	

Rev	Date	Change	Revised By	Approved
A		New issue		

LVS

Pick assy kit

Qty	Part #	Description	Batch #
1	A2530	Handle	B21970
2	A2931	Bumper	B21139
2	MS20600AD4W3	Rivet	M11660
2	AN960JD8	Washer	M9626
2	AN3-16A	Bolt	M14820
2	MS21042L3	Nut	M15066
4	AN5-17A	Bolt	M15702
4	AN960JD516	Washer	M15927
4	MS21042L5	Nut	M15539
2	A2535	Spring	B20827
2	A2537	Bushing	B21548
2	AN4-7A	Bolt	M15321
2	A2022-104	Spacer	M21505
2	AN960JD416	Washer	M5519
2	MS21042L4	Washer	M15020
1	A2332-041	Prop Arm	B21221
1	AN4-20A	Bolt	M12082
2	AN960JD416	Washer	M3154
2	AN970-4	Washer	M16504
4	MS21042L4	Nut	M15020
1	AN4-22A	Bolt	M3735

~~A2530~~

DART AEROSPACE LTD

Description: Lug

Dwg: D3338 Rev. A

Step	Location	Procedure
1	DC	Issue Traveler
2	MV	Cut D2423 extrusion to 0.82" Identify for D3338-1
3	MV	Machine D3338-1 as per Folio FA506 and Check for extrusion defects while load Identify as D3338-1
4	QC2	Inspect parts as they come off the CNC
5	QC8	Second check
6	MV	Tumble and Deburr
7	QC5	Inspect work to Step 6
8	FP	Acid etch and Alodine as per QSI 005 4.1
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1)
10	QC3	Inspect Powder Coat
11	ST	Identify and Stock
12	AC	Cost / part: , 86
13	DC	Close W/O - YG Inspect Level 21

Rev	Date	Change
A	05.02.09	New issue

DART AEROSPACE LTD

Work Order: 22211

Description: Basket Base Assembly

Part Number: D3324-041

Dwg: D3324 Rev. A

Qty:

Page 1 of 1

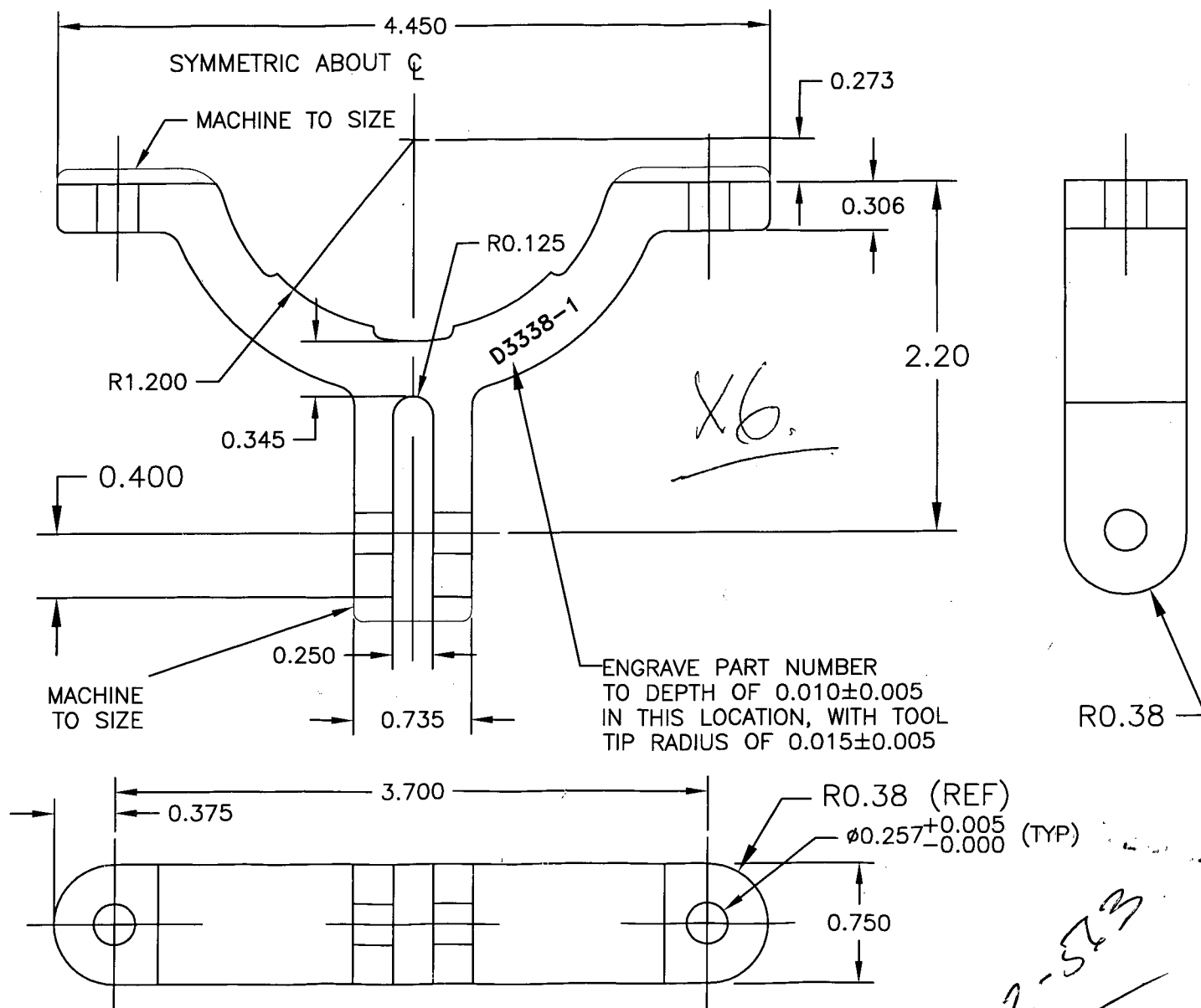
Step	Location	Procedure	By	Date	Qty																								
1	DC	Issue Traveler Dwg not required	JJ	05.01.18	1																								
2	WS	Cut tubes as per Dwg D3324 Material: 4130 Cond. N Square tube per MIL-T-6736, 1/2" x 0.035" wall (M4130N-TS0.500W.035) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>3</td><td>D3324-1</td><td>Bottom Tube</td><td>M16550</td></tr><tr><td>4</td><td>D3324-3</td><td>Full Length Tube</td><td>M16550</td></tr><tr><td>2</td><td>D3324-5</td><td>Top End Tube</td><td>M16550</td></tr><tr><td>2</td><td>D3324-7</td><td>Bottom EndTube</td><td>M16550</td></tr><tr><td>10</td><td>D3324-9</td><td>Vertical Tube</td><td>M16550</td></tr></table> Identify parts appropriately	Qty	Part Number	Description	Batch	3	D3324-1	Bottom Tube	M16550	4	D3324-3	Full Length Tube	M16550	2	D3324-5	Top End Tube	M16550	2	D3324-7	Bottom EndTube	M16550	10	D3324-9	Vertical Tube	M16550	DA	05/01/18	1
Qty	Part Number	Description	Batch																										
3	D3324-1	Bottom Tube	M16550																										
4	D3324-3	Full Length Tube	M16550																										
2	D3324-5	Top End Tube	M16550																										
2	D3324-7	Bottom EndTube	M16550																										
10	D3324-9	Vertical Tube	M16550																										
3	WS	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3328-3</td><td>Hinge Plate</td><td>M16559</td></tr><tr><td>4</td><td>D3348-1</td><td>Clevis</td><td>M16559</td></tr><tr><td>2</td><td>D3349-3</td><td>Spacer Bushing</td><td>M16440</td></tr><tr><td>2</td><td>D3367-1</td><td>Mounting Bracket</td><td>M16559</td></tr><tr><td>28sf</td><td>M569EX0.50-18F</td><td>1/2"-18gauge(.048") carbon steel</td><td>M16440</td></tr></table>	Qty	Part Number	Description	Batch	2	D3328-3	Hinge Plate	M16559	4	D3348-1	Clevis	M16559	2	D3349-3	Spacer Bushing	M16440	2	D3367-1	Mounting Bracket	M16559	28sf	M569EX0.50-18F	1/2"-18gauge(.048") carbon steel	M16440	DA	05/01/18	1
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28sf	M569EX0.50-18F	1/2"-18gauge(.048") carbon steel	M16440																										
4	WS	Remove all markings from material	DA	05/01/18	1																								
5	WS	Drill and Weld as per Dwg D3324 & QSI 004 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>Steel Rod</td><td>M9430</td></tr></table>	Qty	Part Number	Description	Batch	A/R	N/A	Steel Rod	M9430	DA	05/01/18	1																
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A/R	N/A	Steel Rod	M9430																										
6	WS	Deburr as required	DA	05/01/18	1																								
7	QC9/6	Inspect welding and dimensions	DA	05/02/01	1																								
8	WS	Take traveler D350-721-041 to KP	DA	05/02/01	1																								
9	FP	Powder Coat Gloss White (Ref: 4.3.5.2) as per QSI 005 4.3			N/A																								
10	QC3	Inspect Powder Coat			N/A																								
11	FP	To GA for assembly	DA	05/02/01	1																								

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	

RELEASED
05/02/18

Batch Number
M21202

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3338	REV. A SHEET 1 OF 1
DATE 04.11.03	TITLE MOUNTING LUG		SCALE 1:1
A	04.11.03	NEW ISSUE	



D3338-1 NOTES

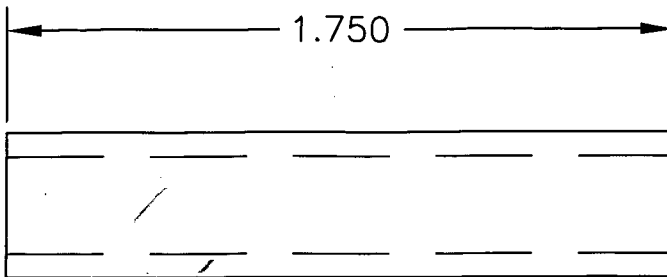
- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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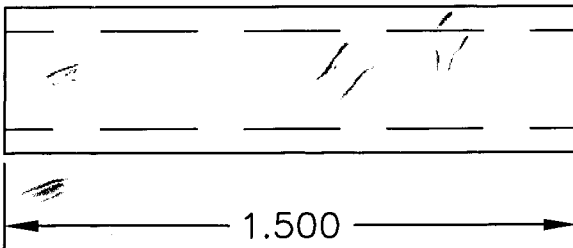
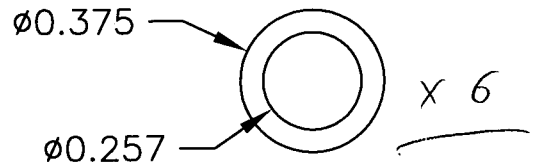
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3349	REV. A SHEET 1 OF 1
DATE 04.11.11	TITLE SPACER BUSHING		SCALE 1:1
A	04.11.11	NEW ISSUE	

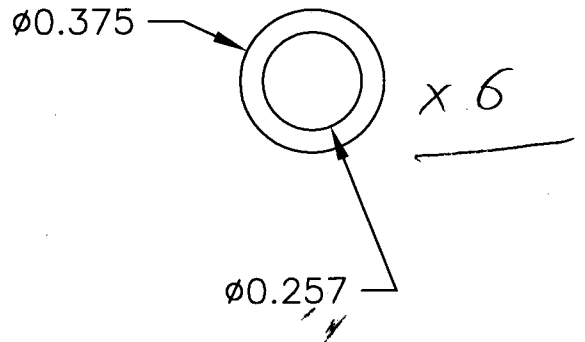
M16440



D3349-1



D3349-3

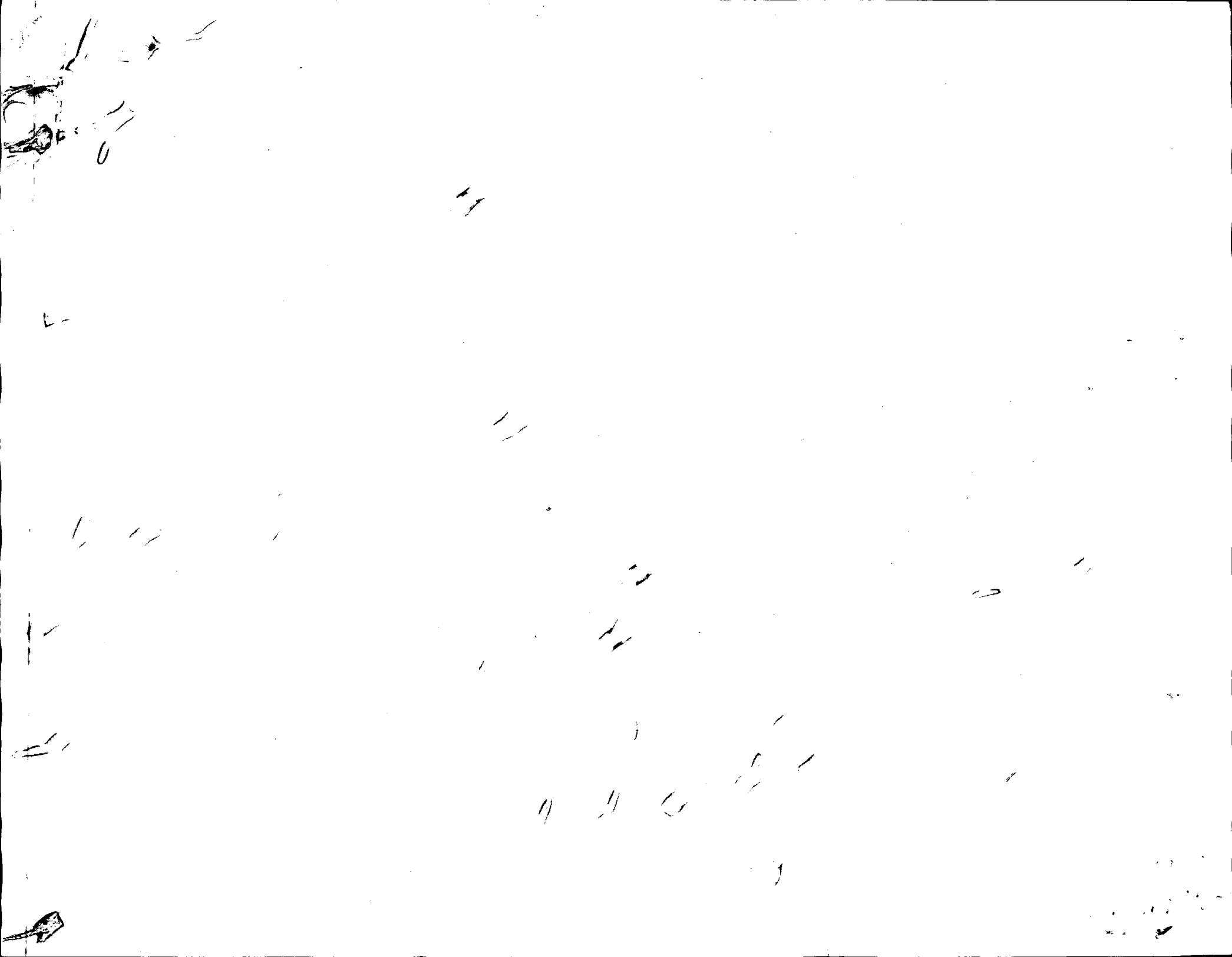


D3349-1/-3 SPACER BUSHING

- 1) MATERIAL: $\phi 0.375$ AISI 1018-1025 ROUND BAR (REF DART SPEC. M1018-R0.375)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1502-563

054.5



P502-563

DART AEROSPACE LTD		Work Order:	22211
Description: Strut		Part Number:	D3350-041
Dwg: D3350 Rev. A		Qty:	3
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	[Signature]	05.03.02	3																				
2	MV	Cut blank: 0.750" x 0.750" x 15.00" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B0.750x00.750) Identify for D3350-1 Batch: M15735	[Signature]	05.03.02	3																				
3	MV	Machine D3350-1 as per Folio FA496 and Dwg D3350 Identify as D3350-1	[Signature]	05.03.02	3																				
4	QC2	Inspect parts as they come off the CNC machine	[Signature]	05.03.02	3																				
5	QC8	Second check	[Signature]	05.03.02	3																				
6	MV	Deburr and Tumble	[Signature]	05.03.02	3																				
7	QC5	Inspect work to Step 6	[Signature]	05.03.02	3																				
8	FP	Acid etch and Alodine as per QSI 005 4.1	[Signature]	05.03.02	3																				
9	FP	Powder Coat Gloss White (Ref: 4-3-5.2) as per QSI 005 4.3	[Signature]	05.03.02	3																				
10	QC3	Inspect Powder Coat	[Signature]	05.03.02	3																				
11	GA	Assemble as per Dwg D3350. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2324-5</td> <td>Strap</td> <td></td> </tr> <tr> <td>2</td> <td>AN3-12A</td> <td>Bolt</td> <td>M15387</td> </tr> <tr> <td>2</td> <td>AN960JD10</td> <td>Washer</td> <td></td> </tr> <tr> <td>2</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td>M15539</td> </tr> </tbody> </table> Identify as D3350-041 and batch number using a fine point permanent marker	Qty	Part Number	Description	Batch	2	D2324-5	Strap		2	AN3-12A	Bolt	M15387	2	AN960JD10	Washer		2	MS21042L3	Nut (or -3)	M15539			
Qty	Part Number	Description	Batch																						
2	D2324-5	Strap																							
2	AN3-12A	Bolt	M15387																						
2	AN960JD10	Washer																							
2	MS21042L3	Nut (or -3)	M15539																						
12	QC5	Inspect work to Step 11	[Signature]	03.05.02	3																				
13	ST	Identify and Stock																							
14	AC	Cost / part:																							
15	DC	Close W/O Inspect Level 21																							

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	[Signature]

RELEASED
05.02.14

Handwritten marks and symbols in the top left corner, including a small circle and some illegible characters.

Handwritten mark resembling a stylized '1' or '7'.

Handwritten mark resembling a stylized 'H' or '4'.

Handwritten mark resembling a stylized '1' or '7'.

Handwritten marks and symbols on the left side, including a small circle and some illegible characters.

Handwritten mark resembling a stylized '1' or '7'.

Handwritten mark resembling a stylized '1' or '7'.

Handwritten marks and symbols on the right side, including a small circle and some illegible characters.

Handwritten mark resembling a stylized 'H' or '4'.

Handwritten mark resembling a stylized '1' or '7'.

Handwritten marks and symbols in the bottom center, including a small circle and some illegible characters.

Handwritten mark resembling a stylized '1' or '7'.

DART AEROSPACE LTD		Work Order:	22211
Description:		Part Number:	D3350-1
Inspection Dwg:	Rev:	Page 1 of 1	



12



12

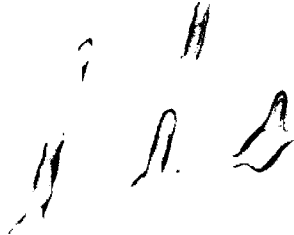


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11

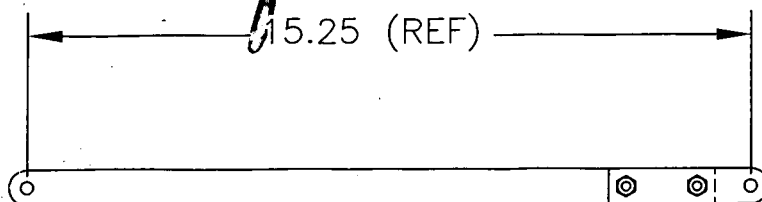


12



12

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3350	REV. A SHEET 1 OF 1
DATE 04.11.12		TITLE STRUT	SCALE 1:4
A0	04.11.12	NEW ISSUE	



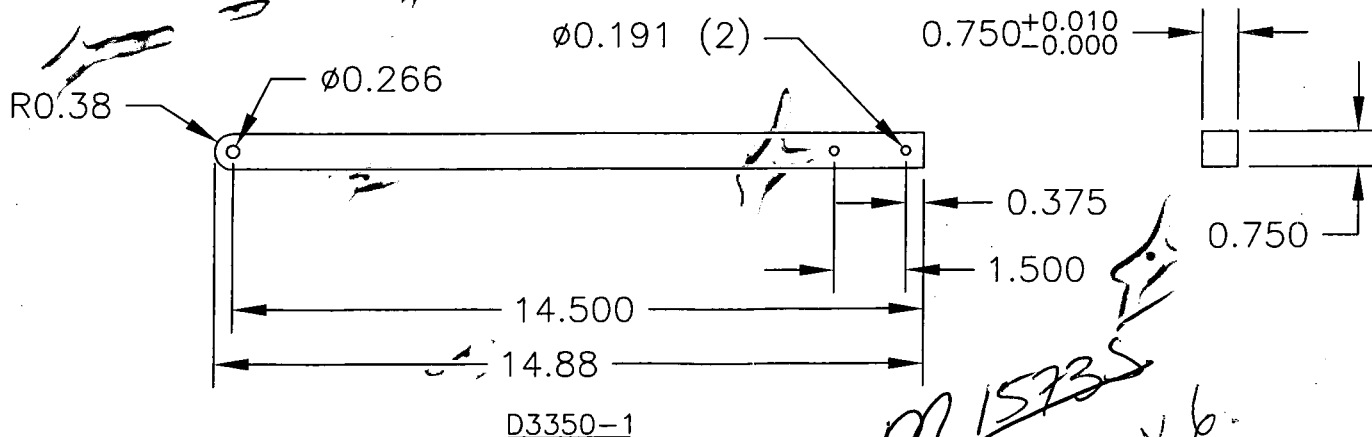
D3350-1

D2324-5

AN3-12A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(TYP 2 PLACES)

D3350-041- STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



D3350-1

D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

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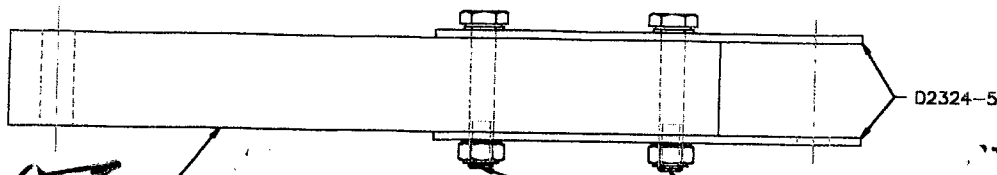
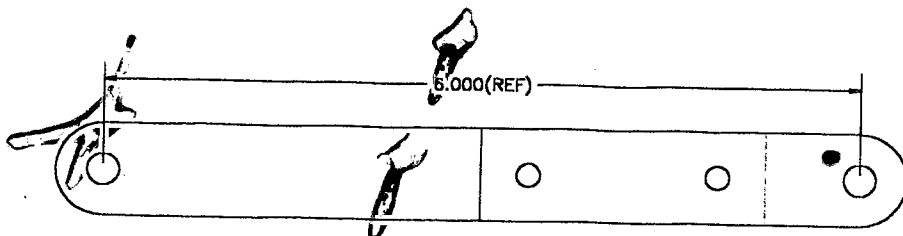


DART



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2324	REV. B
DATE 94:11:08	TITLE STRUT		SHEET 1 OF 1
			SCALE

RELEASED
86 05 07

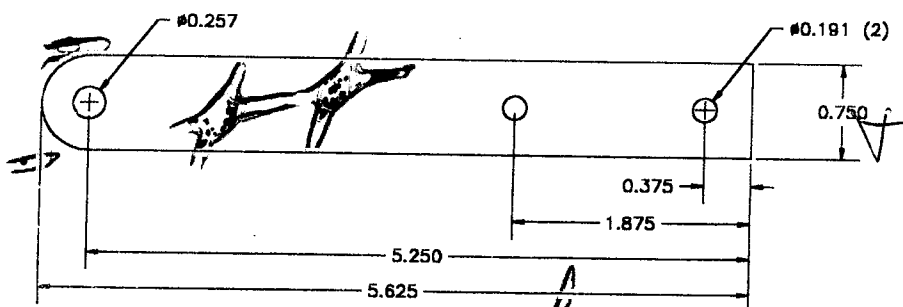


2324-1 STRUT ASSEMBLY

AN3-12A BOLT (1)
AN960JD10 WASHER (2)
MS21047B3 NUT (1)
(TWO PLACES)

MS21042L3 NUT (1)

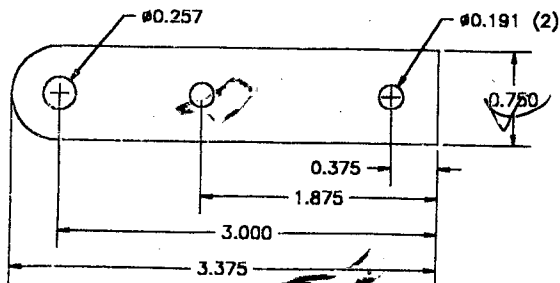
RE 99.01.26



2324-3 MATERIAL: 5052-H34 0.75 X 0.75

or 6061-T6 (QQ-A-250/11) or (QQ-A-200/9) or (QQ-A-225/4)

RE 99.01.26



2324-5 MATERIAL: 304 SS .063 THICK

or AISI 316 SS

RE 99.01.26

7502-563

